

# Work Order ID 58022

April 21, 2010 3:59:21 PM



Page 1

Item ID: D4095-1

Revision ID: PRELIM

Item Name: Wearplate

Start Date: 21/04/2010 Start Qty: 1.00

Required Date: 28/04/2010 Req'd Qty: 1.00

Accept



Setup Start



Stop



Cust Item ID:



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-4-21

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4095

PA+ 10.04.22

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D4095

Dwg Rev: P42

Prog Rev: On Lrm

2-Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

0.00

RB 10-4-22

(2)

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

0.00

→ S 10.04.23 x2  
to PA2 Day only

QC APPROVAL

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 58022**

April 21, 2010 3:59:21 PM



Page 2

Item ID: D4095-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Wearplate

Start Date: 21/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/  
Work Center ID**
**Operation  
Description**
Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

- 1- bend section C-C first
- 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155
- 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157

140



QC5- Inspect part completeness to step on W/O

0.00

→ Fit in skid tube

QC

Quality Control

Memo

Before welding, clean edges.

Ensure joggle as per dwg D4095

0.00

Fit is fit

*S. Balakrishnan*  
QC APPROVAL  
x2  
to pass only

150



Weld per dwg A/R Hardcoat S.S. Batch:

0.00

Large Fab *114373*

Memo

0.00

Large Fab

same template as D3564-1-3

*B. 10-4-23* *(X2)*

W/O:		WORK ORDER CHANGES					
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**Work Order ID 58022**

April 21, 2010 3:59:21 PM



Page 3

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Revision ID: PRELIM

Stop



Item Name: Wearplate

Start Date: 21/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/  
Run Hours

0.00

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID 58022**

April 21, 2010 3:59:21 PM



Page 4

Item ID: D4095-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Wearplate

Start Date: 21/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 1.00



Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

**QC APPROVAL**

②

BL 10-4-26

200

Identify as per dwg &amp; Stock Location:

0.00

58137

Packaging

Memo

0.00

Packaging

② KB 10-4-26

210

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/10/07 JG

MK

POSITIVE RECALL  
 EFFECTIVE 10-4-27 AUTH BY  
 RELEASED DATE 10-10-07

10-4-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

April 21, 2010 3:59:25 PM

Page 1

Work Order ID: 58022



Parent Item: D4095-1



Parent Item Name: Wearplate

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev:A new issue DD 10.04.21 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	0.0000	2.3076		BR 10-4-22	

304/316 Sheet .063

304 .063 114467

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	58023
Description: WEAR PLATE	Part Number:	D4095-1
Inspection Dwg: D4095-1, Rev: PAZ		Page 1 of 1

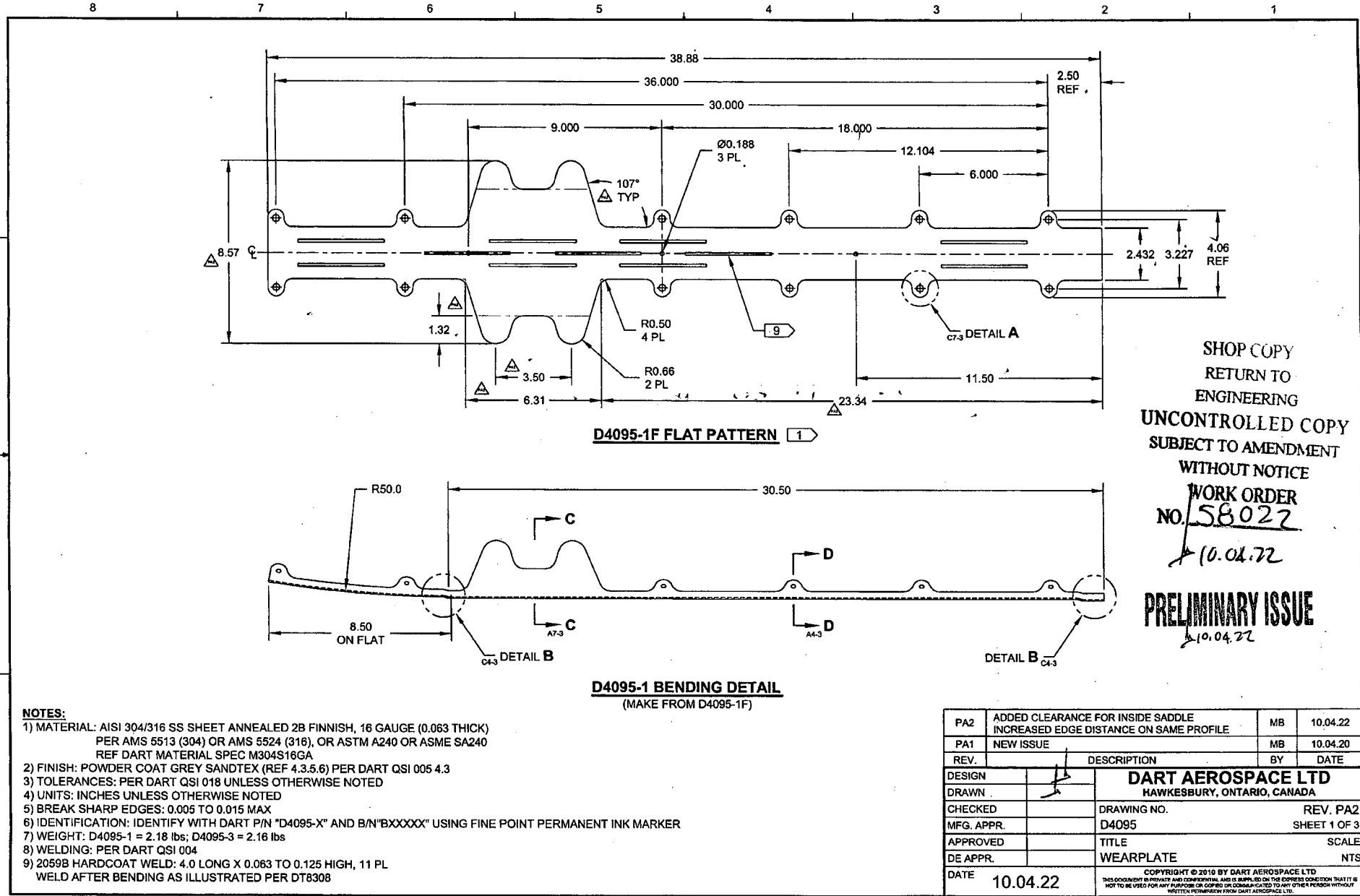
### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.300	+.010	.302	S			
.300	+.010	.303	J			
2.432	+.010	2.432	X			
3.227	+.010	3.224	J			
4.06	-.030	4.055	S			
2.50	-.030	2.502	J			
11.50	-.030	11.50	S			
23.34	-.030	23.34	J			
6.31	-.030	6.31	J			
3.50	-.030	3.50	S			
1.32	-.030	1.333	S			
8.57	-.030	8.568	J			
6.000	-.010	5.997	J			
12.104	-.010	12.104	J			
18.000	-.010	18.000	J			
9.000	-.010	9.000	S			
30.000	-.010	30.000	S			
36.000	-.010	36.000	S			
38.88	-.030	38.875	J			
.188	+.005 - .001	.189	X			
.063	-.010	.059	J			

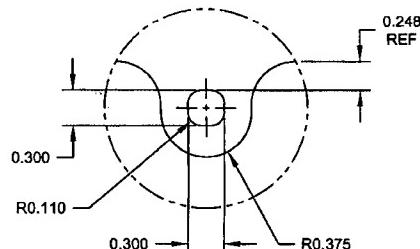
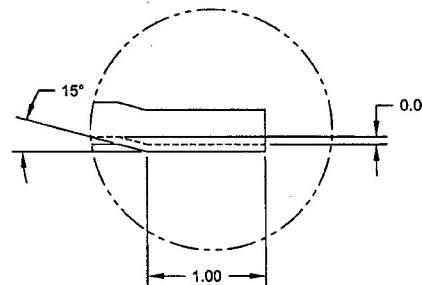
Measured by:	HB	Audited by:	S	Prototype Approval:	
Date:	10-4-23	Date:	10/04/23	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



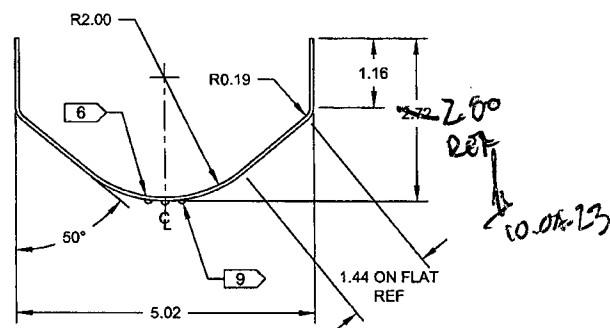
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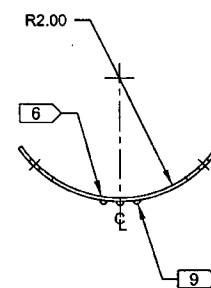
**DETAIL A: TAB DETAIL**SCALE 4X  
B3-1  
B4-2**DETAIL B: JOGGLE DETAIL**SCALE 4X  
B3-1  
B4-1  
B4-2  
B7-2

C

B

**SECTION C-C**SCALE 2X  
B5-1  
B4-2

A

**SECTION D-D**

SCALE 2X

SHOP COPY  
RETURN TO  
ENGINEERING  
**UNCONTROLLED COPY**  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 58022  
10.04.22

**PRELIMINARY ISSUE**  
10.04.22

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. PA2
MFG. APPR.		SHEET 3 OF 3
APPROVED		TITLE
DE APPR.		WEARPLATE
DATE	10.04.22	SCALE NTS

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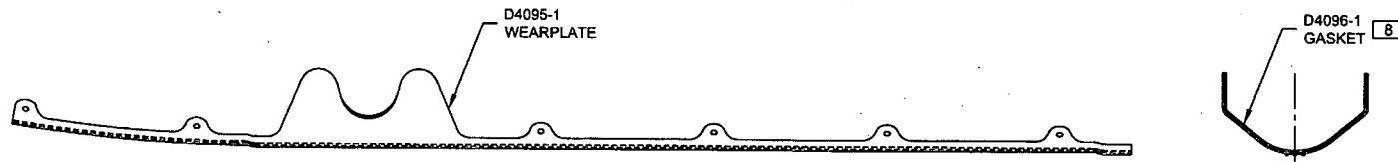
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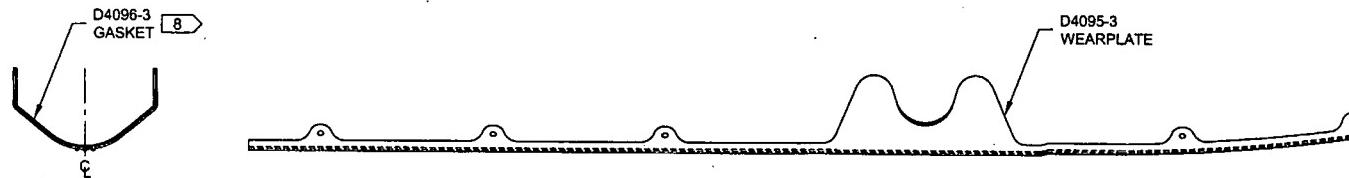
B

A

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D4095-041	WEARPLATE ASSEMBLY
2		X	D4095-043	WEARPLATE ASSEMBLY
3	1		D4095-1	WEARPLATE
4		1	D4095-3	WEARPLATE
5	1		D4096-1	GASKET
6		1	D4096-3	GASKET
7	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE



D4095-041 WEARPLATE ASSEMBLY



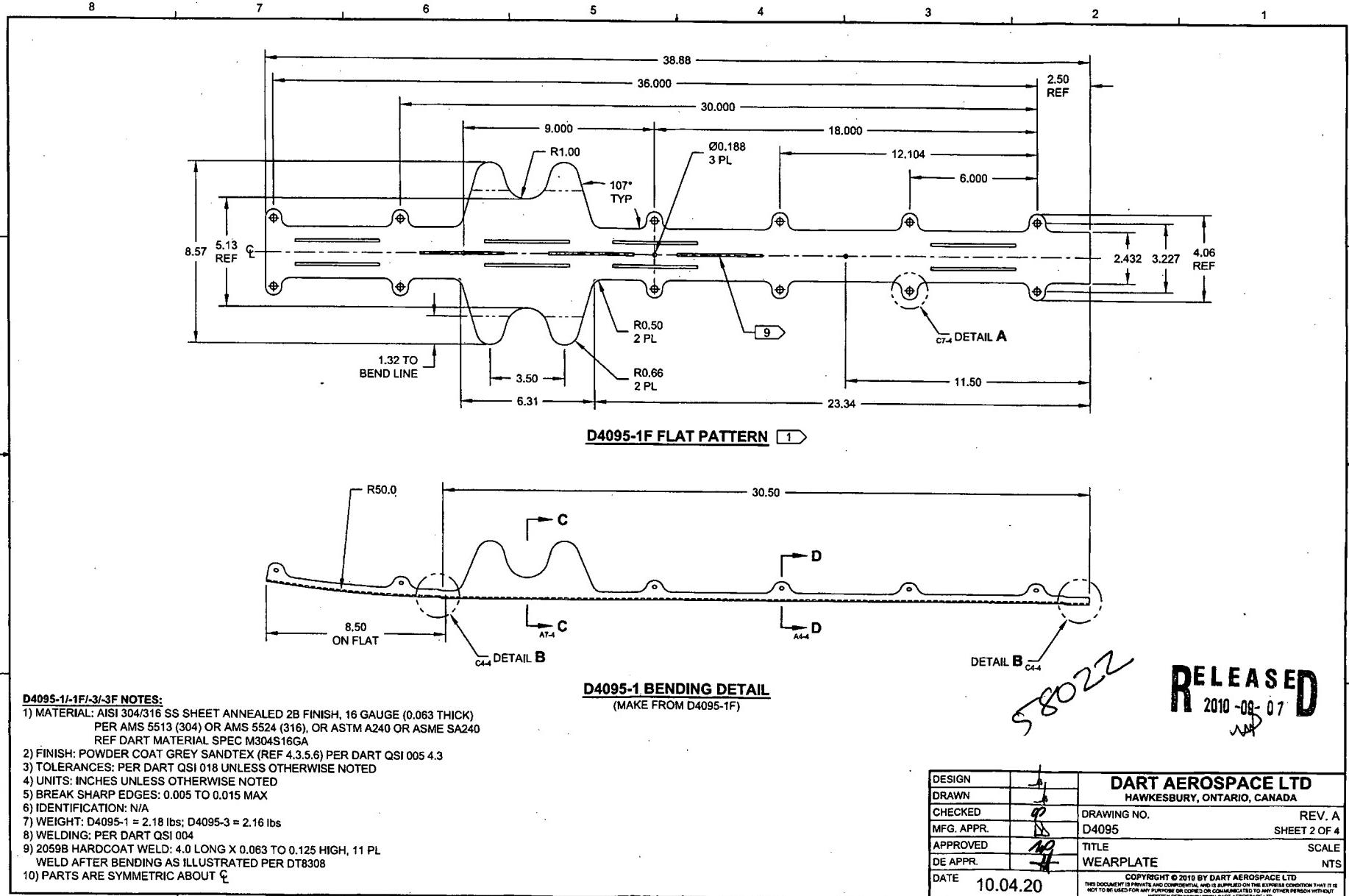
D4095-043 WEARPLATE ASSEMBLY

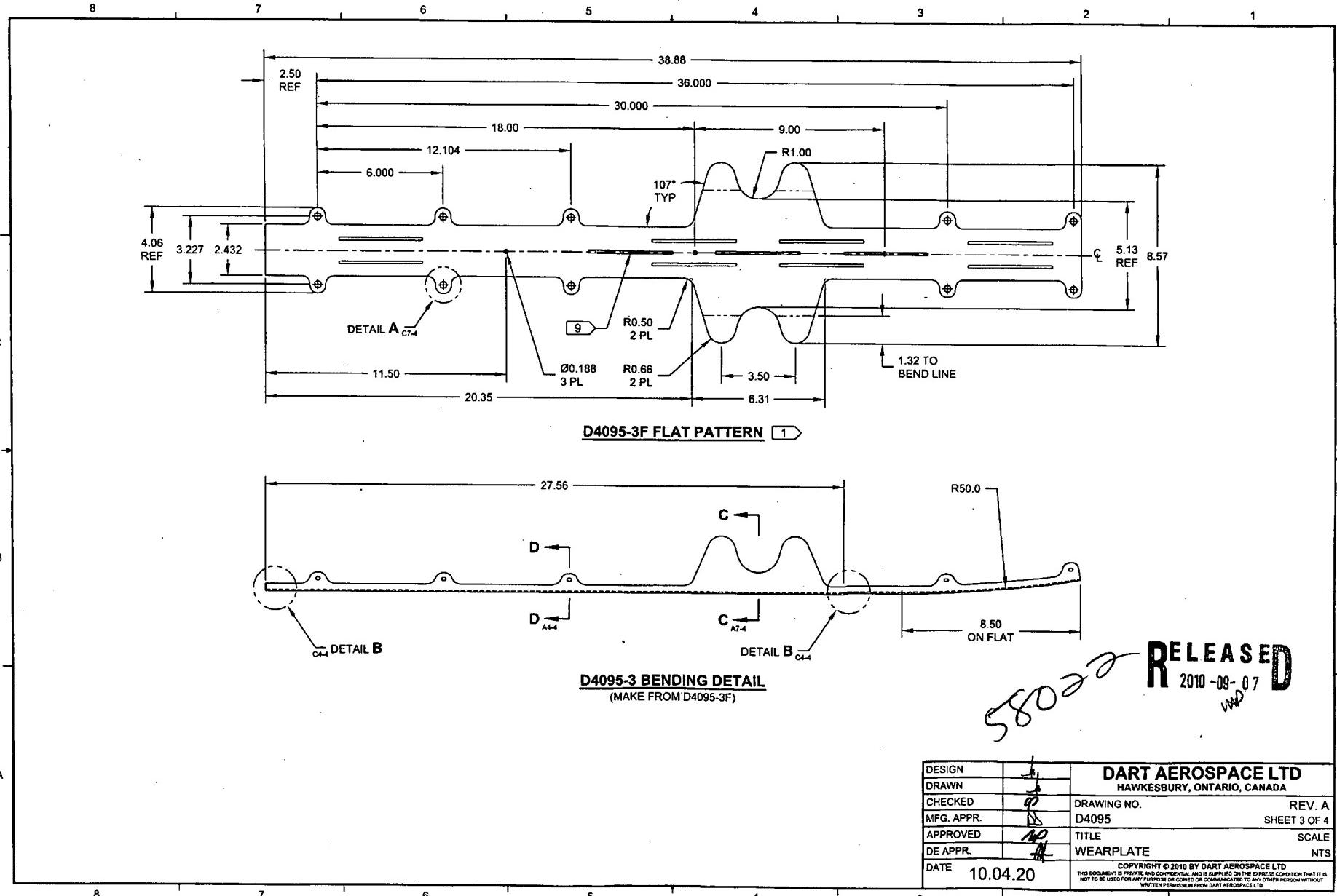
RELEASED  
2010-09-07  
58022

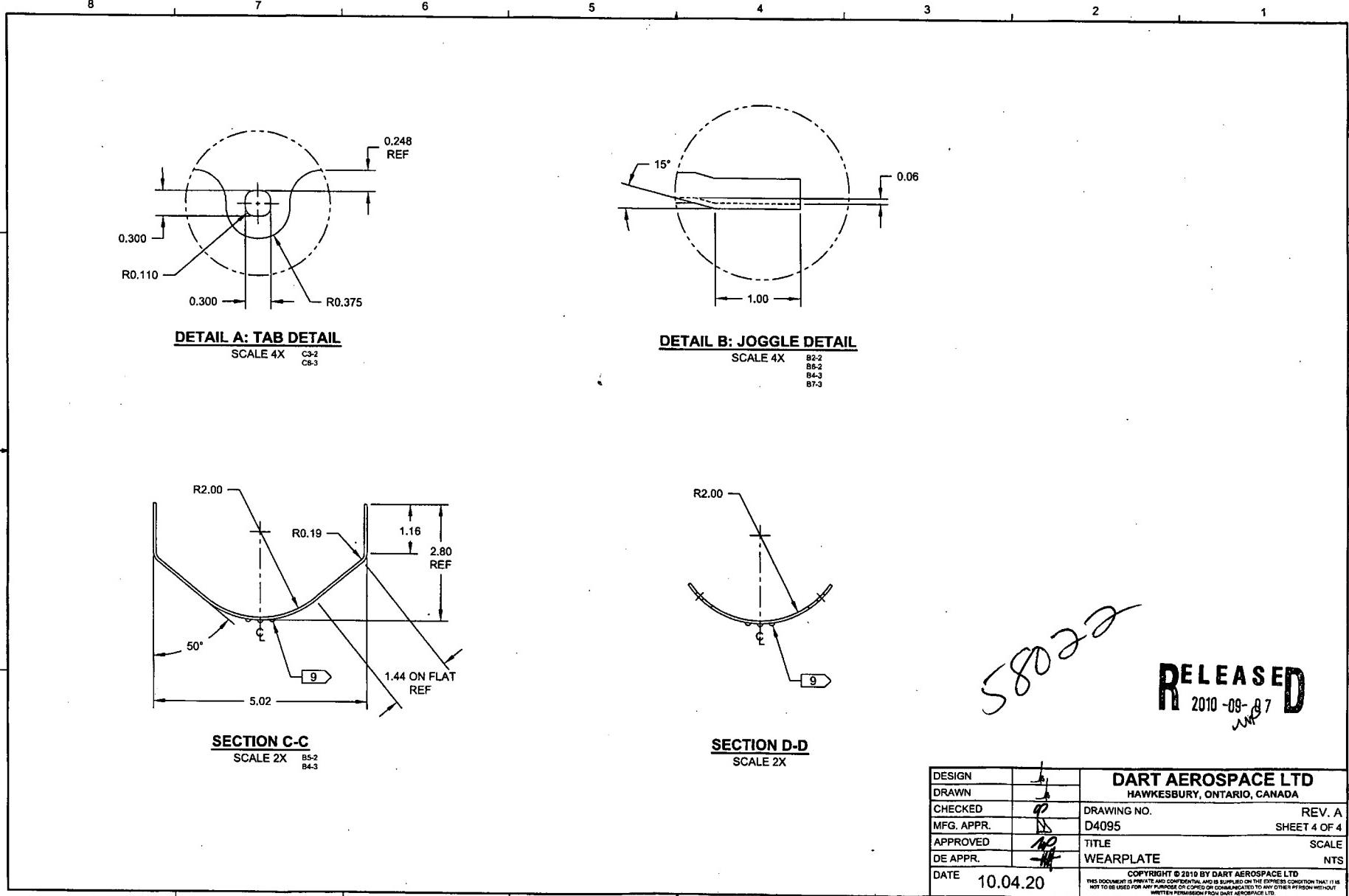
**D4095-041/043 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-04X" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4095-041 = 2.60 lbs; D4095-043 = 2.58 lbs
- 8) AFTER FINISH, BOND GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 9) PARTS ARE SYMMETRIC ABOUT C

A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN	1		
DRAWN	1		
CHECKED	PP		DRAWING NO. REV. A
MFG. APPR.	DA	D4095	SHEET 1 OF 4
APPROVED	MM		TITLE SCALE
DE APPR.	MM		WEARPLATE NTS
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DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D4095                    REV. A
APPROVED	<i>[Signature]</i>	SHEET 4 OF 4
DE APPR.	<i>[Signature]</i>	TITLE
		WEARPLATE                    NTS
DATE	10.04.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT BE NOT TO BE USED FOR ANY OTHER PURPOSE OR COPIED OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

## Location/Lot Activity

October 7, 2010 1:32:50 PM

Page 1 of 1

Criteria : All Items All Locations Lot: 58022 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date	Extended Cost
Issue	D4095-1 / Wearplate	Main Warehouse ENG	58137	FAUT01		2.0000		2.0000		
WIP Receipt	D4095-1 / Wearplate	Main Warehouse ENG	58022	FAUT01	4/27/10	-2.0000	58022	-2.0000		-\$202.41

✓

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